

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



Tel (613) 632-5200
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D5635-041BENT
Job Sheet 200847



Part No: D5635-041BENT

Job Qty: 4 pcs

Part Name: Standard Skidtube



Part Weight: 0 lbs

Status: New

Job Created: 9/18/19

Job Tracking No:

Priority: Medium

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5635 REV.A IPP REV:A 19.06.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
							Workcenter / Supplier Lead Time	
110	Skidtubes - Bend - 1	4 pcs	10/4/19		0.50	1.33	Skidtubes - Bend	MGC
120	QC 5	4 pcs	10/4/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	BE
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	
30	Packaging 3-1 - Stock - B4B	4 pcs	10/4/19		0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
							Packaging 3 - 11 - B4B	



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CANADA
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Container No: S217086



Part: D5635 - 041BENT

Job No: 200847

Serial No/Batch: S217086

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 09/26/19

				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B	BE				
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - SA	4 pcs	10/4/19	0.00 0.00	QC 21 - SA - 21	SEP 26 2019
								QC 21 - SA - 70	
				Part Op 110 - ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Bend FWD end of tube using bend prog Descriptions: D56345FWD and FOLIO 35 as per dwg D5635, cut fwd end of tube with saw table setup D5634 . 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: <u>LG002</u>) LOCATION : LG002 140 - (QC21- Final Inspection - Work Order Release)					
				Job BOM					
				Part / Item	Component Name	Quantity	Operation	Container	
				D2600-1-160	Extrusion Round 3" 206	4 pcs (1 ea)	110-Skidtubes - Bend - 1	5168 238	
				Job Allocations					
				Operation	Component Part	Required	Inventory	Allocated	
				110-Skidtubes - Bend - 1	D2600-1-160	4	21	0	
				Part Specifications					
				Specifications could not be found.					

Plex 9/18/19 12:20 PM Dart.lajeunesse.marie

QTY	PIN	DESCRIPTION
1	D5635-041	STANDARD SKIDTUBE
1	D2946	AFT CAP
21	D4720-1	SPACER
1	D5633-1	TOW STEP
1	D5635-1	SKIDTUBE
1	D5637-1	WEB
2	MS24683-C272	SCREW, CSK 100°

UNCONFIRMED COPY
SUBJECT TO VERIFICATION
OFFICE

40-200847 MJS
19-09-18

D5635-041 SKIDTUBE ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 8.4 ON INNER TUBE SURFACE AT AFT END.
 - 7) WEIGHT: 12.33 lb
 - 8) SEAL MATING SURFACES WITH SIKAFLEX -2411/291 OR PROSEAL PS 8801/422 OR MIL-S-9802 CLASS B2 SEALANT
 - 9) INSTALL FASTENERS WET WITH SIKAFLEX -2411/291 OR PROSEAL PS 8801/422 OR MIL-S-9802 CLASS B2 SEALANT
 - 10) INSTALL WEB INTO OUTER TUBE WITH SIKAFLEX -2411/291 ADHESIVE PER DART QSI 015.
 - 11) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE
WELDING PER DART QSI 004.
 - 12) IT IS PERMISSIBLE TO GRIND SKIDTUBE END TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
 - 14) SLOT FOR D5633-1 TOW STEP THRU BACK WALL ONLY.

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2019 JUN 27
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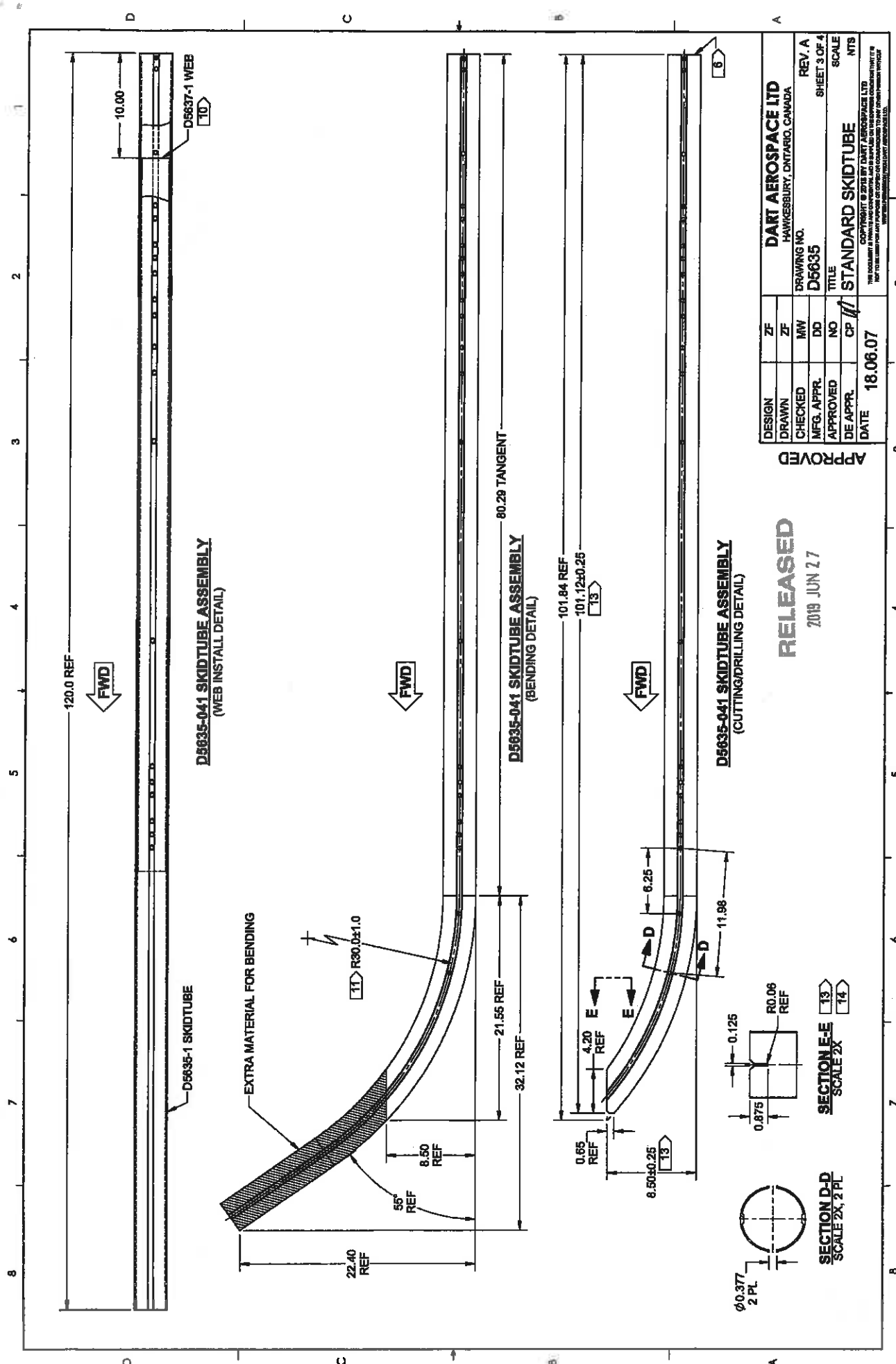
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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details: _____					
Completed By		Lead hand / Supervisor			
		QC / QA Coordinator			